



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

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D3205-1
Job Sheet 200372



Part No: D3205-1

Job Qty: 6 pcs

Part Name: Pedal Bracket



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/10/19

Job Tracking No:

Created By: Marie Lajeunesse

Due Date: 10/15/19

Description:

Type: Stock

Note: DWG REV C IPP A 04.06.09 New issue KJ/RF IPP Rev:B 08-12-16 attach DEO DD verified by:EC IPP REV:C
AS PER REV B 12-03-23 JLM VERIFIED BY:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	6 pcs		10/15/19	0.00	0.69	Bandsaw - 1		DJP A-11-08
110	HAAS 4 Axis - B4B	6 pcs		10/15/19	0.58	24.00	HAAS - 1 - B4B	DAS 52	19/11/09
							HAAS - 2 - B4B	9-89	
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		
120	QC 2	6 pcs		10/15/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51	DAS	
							QC 2 - 52	52	19/11/09
							QC 2 - 57	9-89	
							QC 2 - 62		



Container No: S229986



Part: D3205-1

Job No: 200372

Serial No/Batch: S229986

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 11/08/19

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CANADA
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						QC 2 - 63	
						QC 2 - 8	
						QC 2 - 66	
						QC 2 - 64	
						QC 2 - 65	
						QC 2 - 5	
						QC 2 - 71	
						QC 2 - 73	
						QC 2 - 69	
121	Conventional Mill - 1 - B4B	6 pcs	10/15/19	0.00	6.00	Conventional Mill - 1 - B4B	N/ 19/11/19
						Conventional Mill - 2 - B4B	
122	QC 2	6 pcs	10/15/19	0.00	0.00	QC 2 - 1	
						QC 2 - 12	
						QC 2 - 14	
						QC 2 - 17	
						QC 2 - 19	
						QC 2 - 2	
						QC 2 - 20	
						QC 2 - 22	
						QC 2 - 23	
						QC 2 - 25	
						QC 2 - 32	
						QC 2 - 33	
						QC 2 - 35	
						QC 2 - 39	
						QC 2 - 4	
						QC 2 - 40	
						QC 2 - 44	
						QC 2 - 45	
						QC 2 - 48	
						QC 2 - 49	
						QC 2 - 50	
						QC 2 - 51	
						QC 2 - 52	
						QC 2 - 57	
						QC 2 - 62	
						QC 2 - 63	N/ 19/11/19
						QC 2 - 8	
						QC 2 - 66	
						QC 2 - 64	
						QC 2 - 65	
						QC 2 - 5	
						QC 2 - 71	
						QC 2 - 73	
						QC 2 - 69	
130	QC 8	6 pcs	10/15/19	0.00	0.00	QC 8 - 12	
						QC 8 - 14	
						QC 8 - 17	
						QC 8 - 20	
						QC 8 - 25	
						QC 8 - 3	
						QC 8 - 32	
						QC 8 - 33	
						QC 8 - 35	
						QC 8 - 39	
						QC 8 - 4	
						QC 8 - 44	

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					QC 3 - 30	
					QC 3 - 34	
					QC 3 - 36	
					QC 3 - 41	
					QC 3 - 51	
					QC 3 - 58	
					QC 3 - 59	
					QC 3 - 68	
					QC 3 - 9	
					QC 3 - 40	
					QC 3 - 19	
					QC 3 - 43	
					QC 3 - 24	
					QC 3 - 61	
					QC 3 - 81	
170	Packaging 3-1 - Stock - B4B	6	10/15/19	0.00 0.00	Packaging 3 - 1 - B4B	
	pcs				Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
180	QC 21 - SA	6	10/15/19	0.00 0.00	QC 21 - SA - 21	
	pcs				QC 21 - SA - 70	
					QC 21 - SA - 53	
Part Op 100 - (Bandsaw) Cut blanks: 3.250" x 2.500" x 4.250" long Bar (+0.030/-0.000) Descriptions: 110 - (HAAS CNC Vertical Machine) Machine D3205-1 as per Folio FA346 and Dwg D3205 Identify as D3205-1 120 - (QC2- Inspect parts off machine FAI/FAIB) 121 - (Manufacture as per dwg) COUNTER SINK AS PER DWG 122 - (QC2- Inspect parts off machine FAI/FAIB) 130 - (QC8- Inspect parts - second check)						

9/10/2019

[Dart Hawkesbury] Job Sheet - Lajeunesse, Marie

- 140 - (Chemical Conversion Coat per QSI005 4.1)
150 - (Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3) Note: Cover the thread hole for D3205-1 before powder coat.
160 - (QC3- Inspect Part Finish)
170 - (Identify as per dwg & Stock Location: _____) LOCATION : GA
180 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M7075T73B2.500X03.25	7075-T73 Bar 2.50 X 3.25	2.1876 ft (.3646 ea)	100-Bandsaw - 1	S/183846

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	M7075T73B2.500X03.25	2	7	0

Part Specifications

Specifications could not be found.

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DART AEROSPACE LTD		Work Order: 200372
Description: Pedal Bracket		Part Number: D3205-1
Inspection Dwg: D3205	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.100	+/-0.010	1.098	✓		Vern.	
0.250	+/-0.010	0.252	✓		Vern.	
R0.38	+/-0.030	0.375	✓		Rad. Gage	
0.125	+/-0.010	0.130	✓		Vern.	
0.250	+/-0.010	0.256	✓		Vern.	
2.380	+/-0.010	2.377	✓		Vern.	
1.380	+/-0.010	1.379	✓		Vern.	
0.500	+/-0.010	0.497	✓		Vern.	
0.880	+/-0.010	0.880	✓		Vern.	
Ø0.470 x 100°	+0.006/-0.001	0.472	✓		Vern. JUDS	
0.440	+/-0.010	0.442	✓		Vern.	
0.600	+/-0.010	0.601	✓		Vern.	
1/4-28UNF-313	N/A	1/4-28UNF	✓		GO-NO GO	
0.250	+/-0.010	0.243	✓		Vern.	
Ø0.257	+0.006/-0.001	0.258	✓		Vern.	
1.750	+/-0.010	1.753	✓		Vern.	
0.870	+/-0.010	0.870	✓		Vern.	
0.440	+/-0.010	0.444	✓		Vern.	
R0.25	+/-0.030	0.250	✓		Rad. Gage	
3.000	+/-0.010	2.999	✓		Vern.	
3.96	+/-0.030	3.963	✓		Vern.	
0.409	+/-0.010	0.409	✓		H.G.	
0.808	+/-0.010	0.809	✓		H.G.	
2.562	+/-0.010	2.567	✓		Vern.	

Measured by: DAS 52 9-89 / [Signature]	Audited by: [Signature] DAS 23 9-89	Preliminary Approval:
Date: 12/1/09	Date: 12/1/12	Date:

Rev	Date	Change	Revised by	Approved
A	05.02.17	New Issue	KJ/JLM	
B	12.05.14	Dimensions updated per Dwg Rev B	KJ	
C	13.02.27	Dwg Rev updated	KJ	[Signature]

Entered: _____ Date: _____ **WORK ORDER NON-CONFORMANCE / ROUTE UPDATE**

Route update only

NCR No. _____

Job: _____

Part No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐

DEPARTMENT/PROCESS

Skid-tube ☐
Machining ☐
Large Fab ☐

Cross tube ☐
Small Fab ☐
Finishing ☐

Eng. (Non-AW) ☐
Prod. Eng. Coord. ☐
Rec/Store/Packaging ☐

Engineering ☐
Water Jet ☐
Supplier ☐
Quality ☐

Date: _____

Sequence #: _____

QTY Affected: _____

MRB (QSI042)

Description Work Order Deviation

Disposition

Completed By _____

Lead hand / Supervisor _____

QC / QA Coordinator _____

Root Cause

Operator ☐
Manufacturing Process ☐
Equip/Tooling ☐
Handling/Preservation ☐
Material ☐
Product Improvement ☐
Process Improvement ☐
Human Factors ☐

FAULT CATEGORY

Pressure/Forced	Contamination	Power Loss/Surge	Positioned Wrong
Bending	Misaligned/off center	Folio/Program	Outside Tolerance
Crushing	BOM/Route	Grain Direction	Drawing
Cracks	Broken/Damage/Defect	Weld	Finish
Crimp/Kink/Ripple/Wave/Twist	Incomplete/Unclear Instructions	Wrong Stock Pulled	Part Lost/Missing
Marks/Chatter	Drill Holes	Out of Sequence	Misread
Mislabeled	Fit/Function	Off-set/Set-up	

Other/Details: _____